

Date: Wednesday, 1/31/2007 2:34:21 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 30510		
Estimate Number	: 10022		
P.O. Number	: <i>N/A</i>	Part Number	: D205634011
This Issue	: 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number	: <i>N/A</i>
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LANDING GEAR	Drawing Revision	: <i>N/A</i>
Previous Run	: 30509	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 2/28/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.02.01		
Comment	: Est Rev: P 02.08.28 Removed QC5 from Step 5 KJ		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D205-634-011 CHG004

*KS 07.02.08*

2.0	30510A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B *30510A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit *30052*1 D205-634-041 Skidtube Assembly(ref) *30510A**07/03/22 SPD*

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

*07/03/22* *07/03/22*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/28

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:34:22 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 30510

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: H

7.0 QC21 FINAL INSPECTION/W/O RELEASE

7.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 87-03-23

30510A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:34:49 PM  
 User: Kim Johnston

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SKID TUBE ASSEMBLY
Job Number :	30510A		
Estimate Number :	10023		
P.O. Number :	N/A	Part Number :	D205634041
This Issue :	1/31/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2580 REV C
First Issue :	N/A	Project Number :	N/A
Previous Run :	30509A	Drawing Revision :	C
		Material :	N/A
		Due Date :	2/28/2007
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>07.02.01</u>		
Comment :	Est Rev. N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ		
	Est Rev. O 06.02.28 Added paperwork EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634 CHG001

N/A

2.0

D25001190

Ext'n -1' Beam Tube 4"



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B 39602

JB 7-2-19

3.0

D2596

205 Web



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B 29722

JB 7-2-21

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

JB 7-2-19

JB 7-2-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30510A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

*Pm 07-02-21*

6-Countersink holes as per Dwg D2580 without cutting fluid

*Pm 07-02-21*

7-Deburr and blow out all chips from inside of tube

*Pm 50 7-2-21*

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

*Pm 50 7-2-21*

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *M102672*

Sikaflex expire date: *7-2-28*

Start Time: *1:30* Date: *7-2-21*

Fin Time: *3:30pm* Date: *7-3-1*

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

*> DP 7-3-1*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

*Pm/EL*

*7-3-1*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*for 03070*

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1 Each(s)/Unit Total: 1 Each(s)

Pick:

Qty Part Number Description Batch  
1 D2576-3 Step *229486*

*BE 07-03-08*

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20 Each(s)/Unit Total: 20 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30510A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:



20

D2579

Spacers

B 30220 BE 07-03-08

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required. BE 07-03-08

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M103317 BE 07-03-08

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M103317 BE 07-03-08

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending fm 07-03-08 (1)

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr fm 07-03-08 (1)

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes fm 07-03-08 (1)

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr fm 07-03-08 (1)

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr fm 07-03-08 (1)

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

A 07/03/12

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

A 07/03/12

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

A J

07-03-14 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30510A

Part Number: D205634041

Job-Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M/10 3706



@

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h

07/03/19

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



20703-29 @



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B29188

17.0

D25773

Wearplate Aft



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B29660

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B28639

19.0

ALS71032130

Insert



Comment: Qty.: 44 Each(s)/Unit Total : 44 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	m/03495

\*

FA/Q.M

07/03/19 @

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30510A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44 Each(s)/Unit Total : 44 Each(s)

Pick:

Qty Part Number Description Batch

4 4 AN960JD10L Washer

m 102832

21.0

AN34A

Bolt



Comment: Qty.: 44 Each(s)/Unit Total : 44 Each(s)

Pick:

Qty Part Number Description Batch

44 AN3-4A Bolt

m 100857

22.0

D25941

Plug



Comment: Qty.: 16 Each(s)/Unit Total : 16 Each(s)

plug

Batch: B29490

23.0

D25943

O-Ring



Comment: Qty.: 16 Each(s)/Unit Total : 16 Each(s)

o-ring

Batch: B27168

24.0

D2855

Cap



Comment: Qty.: 1 Each(s)/Unit Total : 1 Each(s)

Cap

Batch: B27488

25.0

AN35A

Bolt



Comment: Qty.: 2 Each(s)/Unit Total : 2 Each(s)

Bolt

Batch: m15205

FL/am 02/03/19 ①

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/13/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:34:49 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 30510A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 2 Each(s)/Unit Total: 2 Each(s)

Washer

Batch:

*m/02832*

*FL/a.m 07/03/19*

①

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

*m/03497*

Sikaflex expire date: *07/10*

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R

Sikaflex-291

*m/03497*

Sikaflex expire date: *07/10*

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

*m/03480*

*FL/a.m*

Batch:

*07/03/20*

*FL/a.m*  
*07/03/19*

①

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

*PPP*

*B 30510*

*07/3/22*

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*07/03/23*  
*U 07/03/23*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED  
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576-3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

# 00 08.28  
GP 00.08.28

EFFECTIVE	DEOs
98/12/14	00.03.28
DEO 9124	DEO 9183

#### GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES \*
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30510A

DETAIL B  
SCALE 5:24

#00.08.28  
#00.08.28

D2576-3

GRIND FLUSH (4 PLACES)

GRIND FLUSH

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/8"

Diagram illustrating the installation of a D2S75 cap on a bolted joint. The assembly includes:

- #0.208**: Drill prior to D2S75 cap installation (2 places).
- AN3-4A BOLT (1)**
- AN96J010L WASHER (1)** (2 places).
- D2S75 CAP**
- SEAL WITH SIKAFLEX-241**

Diagram of a wheel assembly with labels:

- D2579 SPACER
- D2596 WEB (REF)
- 7-1032-130 (REF) (TYP 44 PLACES)
- AFTER PERFORMING
  1. CH
  2. INS
  3. WE
  4. C'B

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3  
7

1.750 1.750

#0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0

91.500

190.0  
(D2500-1)

0.5 1.5 1.5 D P P P P P P P

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

WELD AS PER DETAIL B

REFER TO DETAIL C

D2577-3 D2577-5 D2577-1


8

AN3-4A BOLT (1)  
AN660JD10L WASHER (1)  
(44 PLACES)

DESIGN *DM* DRAWN BY *CP*

**PART**

RELEASE  
98/09/17 DS

DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD HARRISBURY, ONTARIO, CANADA	REV. C
CHECKED <i>DAH</i>	APPROVED <i>AS</i>		DRAWING NO. D2580
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SHEET 2 OF 2 SCALE 1:24

**Jason Murdoch**

---

**From:** Bill Beckett [bbeckett@dartaero.com]  
**Sent:** Monday, February 05, 2007 1:10 PM  
**To:** 'Jason Murdoch'  
**Cc:** 'L Lacelle'  
**Subject:** RE: sikaflex-291

Jason,  
Yes.  
Bill

---

**From:** Jason Murdoch [mailto:jmurdoch@dartaero.com]  
**Sent:** February 5, 2007 12:49 PM  
**To:** 'Bill Beckett'  
**Subject:** sikaflex-291

Bill,  
We have 25 tubes of sikaflex-291, batch M102672, that expires at 02/2007. Is it acceptable to use the remainder until the end of this month?

jmurdoch@dartaero.com  
Q.C. COORDINATOR

NO. 97

**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A205634041 / B305104

**TEST WELDS REQUIRED**

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

**TEST RESULTS**

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/03/08 Qualifier David Nawal

Date: Friday, 09/02/2007 9:59:35 AM  
User: Linda Lacelle

# Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-635 / D204-635
Job Number : 30722	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z-CUSTOM ECN952/908
This Issue : 09/02/2007 S.O. No. : N/A	Drawing Number : UPDATE PAPERWORK
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : OVERHEAD	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : _____	Due Date : 16/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

ADD NEW PAPERWORK TO KITS IN STOCK

TC STC SH96-88, ISSUE 3 / FAA STC SR00563N4

D205-634-011

D205-634-041

D205-634-043

D205-634-045

D204-635-011

D204-635-041

*voir papier  
avec ✓*

*7/4/27 SQ*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

RETURN TO STOCK

*7/4/27 SQ*

Date: Friday, 09/02/2007 9:59:35 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D205-635 / D204-635
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Written By : _____	Due Date : 16/02/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

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D205-634-045

D204-635-011

D204-635-041

Voik papers  
 under ✓

7/4/27 SQ

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 RETURN TO STOCK

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